	er ID 91752 ober 17, 2012 1:46:37 I	PM	•	*0	175	52*			$\langle \langle \rangle$	Tú	P	pn H	Page 1
Item ID: Pavision ID:	D350-567-117			Accept		*N900	040	100)* ·	<i>V /</i> Setup	Start		S1*
ž.	Floor Window Installation	ı, Extra Large									Stop	*N!	S2*
Start Date: Required Date:	10/17/2012 Start Qt 10/19/2012 Req'd Q	-	*1* *1*			Cust Item I						1 (1)	
Reference:			-										
Approvals:	Process Plan:/W	WF	Date: 12~10-1	_			ate:	- 	Ì	Rụn	Start Stop	*N	R1*
	QC:		Date:	SPC (Y/N)):	D	ate:				o o p	*N	R2*
Sequence ID/ Work Center ID	Operatio Descripti			Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr											,	
IIN-D350-567	Rev D		#50										
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110				0.00				(•					
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Packaging		Pick Packing F ***ENSURE I	Cit DT 8439 TEMPLATE	IS INCLUDED***									
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120	QC4- 100%	Inspect kits for	r completeness	0.00	Sec.	1/0/1/2							
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NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	PDATE	•		
								· · · · · ·			QA Closed:	Date	:
Nork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	•					Rework]		Skid-tube	Crosstube]	Water Jet	Engineering
Part !	NO.					Scrap	-		Machining	Small Fab	4	d. Eng. Coor.	Quality Other
NCR I	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/stor	re/Packaging Supplier	J Other
Root					Descr	iption of work order update		nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup													
rocess upplier raining								;					
napproved	i	L	<u> 1</u>				FAUI	LT CATE	GORY		<u> </u>		
Landi	ng (Gear	-			General							
Land	_	Bending Centre No	ot Concer	ntric to C	o/s	Bend BOM/Route	F	Grain Hardwa	re	F	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	lissing	Wrong Stock Pulled
	Cuffs Contamination					Mainte	enance		Part Moved				
	Heat Treat Countersink					Mislabe	eled		Positioned \	Wrong			
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	/Surge	Other
		Ripples in	n Bend			Drill Holes		Offset				·	
8		Torque W	/aves in E	Extrusion	٦ [Drawing		Out of (Calibration				
1	Turning Sequence Finish					Out of	Sequence						

Outside Dimensions

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Wave/Twist in Tube

Folio

Work Order ID 91752 *91752* Page 2 Wednesday, October 17, 2012 1:46:37 PM Item ID: D350-567-117 Accept *N900040100* Setup Start **Revision ID:** Íæm Name: Stop Floor Window Installation, Extra Large **Start Date:** *1* 10/17/2012 Start Oty: 1.00 **Cust Item ID: Required Date:** 10/19/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date: Stop QC: _____ Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Reject **Tool ID** Tool # Plan Accept Reject Insp. **Work Center ID Description Run Hours** Qty Number Stamp Code Qty 130 0.00 Packaging *130* Packaging 0.00 Packaging Identify and pack for shipping as per PPP D350-567-117 Location: 140 QC21- Final Inspection - Work Order Release 0.00 MC5 12-10-18 MC 9 *140* QC 0.00 Memo Quality Control

NCR:	Yes	/	No

DQA: _____ Date: ____

NCR:	es/	/ No					WORK ORDER NON-C	OI	NFORN	MANCE / UP	DATE					
												С	(A Closed:	Date	:	
Work Orde	er:						DISPOSITION				AGAINST I	DEPA	ARTMENT/	PROCESS		
Part N							Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Proc	Water Jet] [Engineering Quality
NCR N	•						Use-as-is Work Order Update		Therm	oforming Large Fab	Finishing Composite			e/Packaging Supplier		Other
Root					Descr	rip	tion of work order update	Ī	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		01	r Non-conformance	Ch	ief Eng	Desc	cription		Date	Verification		QC Inspector
oc/Data																
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Landi	ng (Gear					General		_					_	_	
		Bending					Bend		Grain				Ovalized		Pr	essure/Forced
		Centre No	ot Concer	ntric to	o/s [BOM/Route		Hardwa	re			Over/Under	tolerance	T∈	emperature/Cure
		Cracks					Broken/Damaged		Inspecti	on Incomplete		F	Part Incorred	t L		'eld
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete	/Unclear	F	Part Lost/Mi	ssing	w	rong Stock Pulled
		Cuffs			Γ		Contamination		Mainte	nance		f	Part Moved			·
		Heat Trea	it		Γ		Countersink		Mislabe	led			Positioned V	Vrong		
		Inspection	n Strip in	Tube	Γ		Cut Too Short		Misread	I			Power Loss/	Surge [0	ther
à		Ripples in	Bend				Drill Holes		Offset			_				
٠,		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration		_				
•		Turning S	equence				Finish		Out of S	Sequence		_		·		
		Wave/Tw	ist in Tub	oe			Folio		Outside	Dimensions						

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Page 1

Work Order ID:

91752

Parent Item:

D350-567-117

Parent Item Name:

Floor Window Installation, Extra Large

Start Date: 10/17/2012

Required Date: 10/19/2012

Start Qty: 1.00

Required Qty: 1.00

	Comments:	IPP Rev:A 08.09	0.30 new issue	EC v	erified by: DI)								
	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
δ	D350-S67-031 C(-(,	iding Door Compatible)	Manufactured	No			110	Each	0.0000		B	9/7	5 3	. 80
5	D350-567-113 Replacement Window, Ex	(いひ) ktra Large	Manufactured	No			110	Each	3.0000		B.10	7/7	5 <u>y</u>	(2)
					Location FG042		Loc Qty	<u>Lo</u>	c Code			. /	<u> </u>	ST 10-10
					859	948	1					/	2-1	018

2

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											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORM	AANCE / UPD	ATE	•		
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
Part N						Rework Scrap Use-as-is		ſ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update	_		Large Fab	Composite	Nec/3tol	Supplier	J Other
Root					Descr	ription of work order update	1	nitial	Actio	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspector
oc/Data													
quip/Tooling													
perator	Ш						1						
<i>M</i> aterial													
etup											, '		
Other					,		ŀ						
rocess													
upplier					: :								
raining													
Inapproved											L		
				 			FAUL	T CATE	GORY				
Landi	ng (3				General		Grain		<u> </u>	Ovalized	Γ	Pressure/Forced
	<u> </u>	Bending	· · · · · · · · · · · · · · · · · · ·		o/s -	Bend BOM/Route		Hardwa		<u> </u>	Over/Under	toloranco	Temperature/Cure
	-	Centre No Cracks	ot Concer	יונרוכ נס י	^{0/3} -	Broken/Damaged	-	1	ion Incomplete	 	Part Incorre	<u> </u>	Weld
	┝	Crushed/0	Crimpod			Burrs		4 '	ions Incomplete/U	nclear	Part Lost/M		Wrong Stock Pulled
	-	Cuffs	chanped			Contamination	-	Mainte	•	licieal	Part Moved	1331116	Wrong Stock runed
	\vdash	Heat Trea	ıt		-	Countersink	-	Mislabe		<u> </u>	Positioned V	Vrong	
	\vdash	Inspection		Tube	-	Cut Too Short	-	Misread		<u> </u>	Power Loss/		Other
	_	1			-	Drill Holes		Offset		<u> </u>	رد د د د د د د د د د د		<u> </u>
•,	Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing							-1	Calibration				
	Turning Sequence					Finish		┥	Sequence				

Outside Dimensions

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Wave/Twist in Tube

Folio

5.0 **PARTS LIST**

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	(-117)	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
 	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		x				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
 			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
<u> </u>				Х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1				+	D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
 	<u> </u>	1	1			_D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1/1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		_D350-567-1-15	INTERIOR FLOOR WINDOW KIT
1		1			1_	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty	Qty	Qty	Qty	Qty		
-013	-023	-113	-115	-031	Part Number	Description
X X	-023	-113	-113	-031	D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
- ^-	Х				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		Х			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
		^	X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-115	INTERIOR FLOOR WINDOW KIT
				^	D350-567-031	(SLIDING DOOR COMPATABLE)
				-		(SEIDING DOOK COMIL ATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9,OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD	YD	YD				
			<u> </u>	1	D2463-0450	NEOPRENE SEAL
			-	1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
		 	 	1	D3213-041	DOOR ASSEMBLY
		-	1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
		<u> </u>	1 1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
		 	1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
		 	15	20	MS20470AD4-7	RIVET
	L	<u> </u>	· .~		1	L · · · · · · · · · · · · · · · · · · ·

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Revision: **D**

Date: 08.07.08